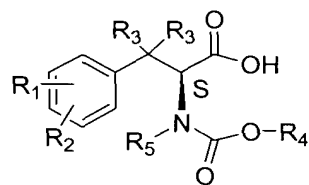


# ABSTRACT

The invention is a process for the preparation of compounds of the Formula I:

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Formula I

10 where R<sub>1</sub>, R<sub>2</sub>, R<sub>3</sub>, R<sub>4</sub> and R<sub>5</sub> are defined in the specification, which are intermediates useful for the preparation of tubulin inhibitors which are useful in the treatment of cancer.

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